

Work Order ID 102049

102049

Page 1

Wednesday, May 22, 2013 4:01:01 PM

Item ID: D4812-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Patient Stop Assembly

Stop

NS2

Start Date: 5/22/2013 Start Qty: 6.00

6

Cust Item ID:

Required Date: 5/31/2013 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

MUF

Date:

13-5-22

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D4812 | A | | | | | | | | |
| 100 | FLOW WATER JET | 0.00 | | | | | | | |
| *100* | | | | | | | | | |
| Waterjet | Memo | 0.00 | | | | | | | |
| FLOW CNC Waterjet | 1- Cut D4812-1F as per Dwg | | | | | | | | |
| | Dwg Rev: A | | | | | | | | |
| | Prog Rev: A | | | | | | | | |
| | 2- DEBURR | | | | | | | | |
| 110 | QC2- Inspect parts off machine FAI/FAIB | 0.00 | | | | | | | |
| *110* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

DAS
05
9-89

13.05.23

DAS
05
9-89

13.05.23

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6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

130

Small Fab

0.00

130

Small Fab

Memo

0.00

Small Fab

1- Form as per dwg D3467

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

SP 13/05/27

Work Order ID 102049

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Wednesday, May 22, 2013 4:01:01 PM

Item ID: D4812-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Patient Stop Assembly
 Start Date: 5/22/2013 Start Qty: 6.00 *6* Cust Item ID:
 Required Date: 5/31/2013 Req'd Qty: 6.00 *6* Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| | | | | | | | | | |
|----------------|---|------|--|--|--|--|--|--|--|
| 150 | Chemical Conversion Coat per QSI005 4.1 | 0.00 | | | | | | | |
| *150* | | | | | | | | | |
| HandFinish | Memo | 0.00 | | | | | | | |
| Hand Finishing | | | | | | | | | |

6 18/3.527

| | | | | | | | | | |
|-----------------|--------------------------------------|------|--|--|--|--|--|--|--|
| 160 | QC7-Inspect Chemical Conversion Coat | 0.00 | | | | | | | |
| *160* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

6x Ø m/f 13/05/28

| | | | | | | | | | |
|----------------|--|------|--|--|--|--|--|--|--|
| 170 | White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum | 0.00 | | | | | | | |
| *170* | | | | | | | | | |
| Powdercoat | Memo | 0.00 | | | | | | | |
| Powder Coating | | | | | | | | | |

START TIME: 11:00
 OVEN TEMPERATURE: 320°F
 FINISH TIME: 11:30

6x Ø m/f 13/05/28

M125620

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Wednesday, May 22, 2013 4:01:01 PM

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Setup Start *NS1*

Revision ID:

Item Name: Patient Stop Assembly

Stop *NS2*

Start Date: 5/22/2013 Start Qty: 6.00

6

Cust Item ID:

Required Date: 5/31/2013 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC3- Inspect Part Finish

0.00

180

QC

Memo

0.00

Quality Control

6x 1 11 13/05/28

190

0.00

190

Small Fab

Memo

0.00

Small Fab

ASSEMBLE AS PER DWG

4 SB 05/22/22

200

QC5- Inspect part completeness to step on W/O

0.00

200

QC

Memo

0.00

Quality Control

0.00 13722

6

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Wednesday, May 22, 2013 4:01:01 PM

Item ID: D4812-041

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Patient Stop Assembly

Start Date: 5/22/2013 Start Qty: 6.00

6

Cust Item ID:

Required Date: 5/31/2013 Req'd Qty: 6.00

6

Customer:

Reference:

Run Start ***NR1***

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop ***NR2***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

Identify as per dwg & Stock Location: _____

0.00

210

Packaging

Memo

5/22/23

0.00

Packaging

43/7/23 (6)

220

QC21- Final Inspection - Work Order Release

0.00

220

QC

Memo

0.00

Quality Control

13/7/24 (8)

MF
53-7-24

Picklist Print

Wednesday, May 22, 2013 4:01:00 PM

Page 1

Work Order ID: 102049

Parent Item: D4812-041

Parent Item Name: Patient Stop Assembly

Start Date: 5/22/2013

Required Date: 5/31/2013

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A 13.05.21 AS PER DWG REV.A VERF:JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

| | | | | | | | | | | | | | |
|---------|--|--------------|----|--|--|--|------|---------|--|----|--|--|--|
| D2690-6 | | Manufactured | No | | | | Each | 38.0000 | | 12 | | | |
|---------|--|--------------|----|--|--|--|------|---------|--|----|--|--|--|

Lanyard Assembly

Location

Loc Qty

Loc Code

ST014

38

B102 246

12

100513

6

101075

14

94775

9

95935

1

99808

8

D4811-1

Manufactured No

Pin, Quick Release

M6061T6S.063

6061-T6 .063 Sheet

Each 0.0000

B102 048

12

100

sf

282.4125

2.03

12.821053

SB 13/07/22

13.05.23

Location

Loc Qty

Loc Code

MAT021

282.4125

123135

120.2625

124003

80.4

125431

81.75

eklist Print

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Work Order ID: 102049
Parent Item: D4812-041
Parent Item Name: Patient Stop Assembly

Start Date: 5/22/2013

Required Date: 5/31/2013

Start Qty: 6.00

Required Qty: 6.00

MS21042L3

Purchased

No

Each 3,577.0000

12

SB 13/07/22

Nut

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| FP001 | 3 | |
| 122141 | 3 | |
| GA | 18 | |
| 122452 | 18 | |
| ST314 | 268 | |
| 117885 | 32 | |
| 119017 | 55 | |
| 119075 | 138 | |
| 123265 | 43 | |
| ST506 | 3288 | |
| 123900 | 954 | |
| 124291 | 2334 | |

12

MS27039-1-07

Screw

Purchased

No

Each 944.0000

12

SB 13/07/22

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| GA | 2 | |
| 119736 | 2 | |
| ST304 | 42 | |
| 119736 | 42 | |
| ST306 | 400 | |
| 125654 | 400 | |
| ST506 | 500 | |
| 124326 | 500 | |

M 125654

12

NAS1149D0332J

Washer

Purchased

No

Each 802.0000

36

SB 13/07/22

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST293 | 360 | |
| 125268 | 360 | |
| ST294 | 442 | |
| 122973 | 68 | |
| 125044 | 374 | |

M 125807

2

34

Wednesday, May 22, 2013 4:01:01 PM

Shop Packet Print

Page 2

| ITEM | QTY -041 | P/N | PIP PIN |
|------|-------------|---------------|-----------------------|
| | X | D4812-041 | PATIENT STOP ASSEMBLY |
| 1 | 2 | D2960-6 | LANYARD |
| 2 | 2 | D4811-1 | QUICK RELEASE PIN |
| 3 | 1 | D4812-1 | PATIENT STOP |
| 4 | 2 | MS27039-1-13 | SCREW |
| 5 | 2 | MS21042L3 | NUT |
| 6 | 6 | NAS1149D0332J | WASHER |

D4811-1 PIP PIN

D2690-6
6" LANYARD ASSY

D4812-1 PATIENT STOP

D4812-041 PATIENT STOP ASSY

MS27039-1-13 SCREW
NAS1149D0332J WASHER (X3)
MS21042L3 NUT

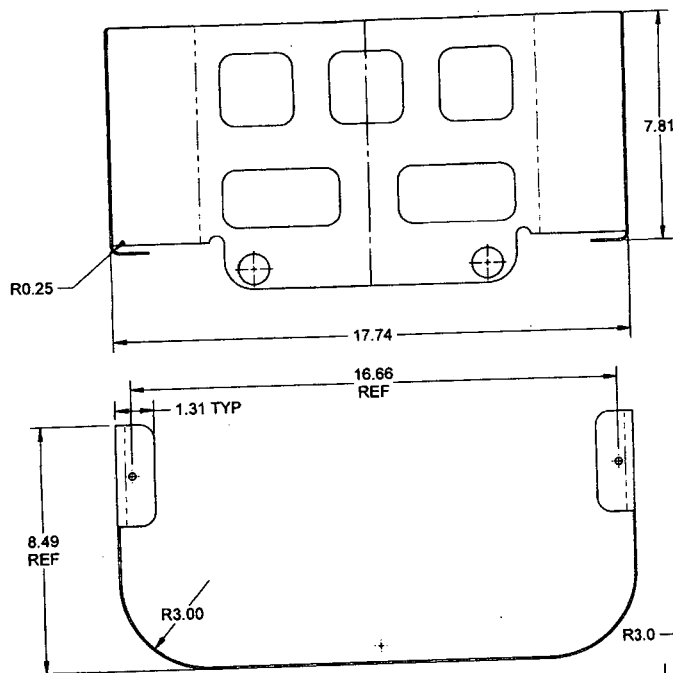
10-2049

RELEASED
2013-05-16

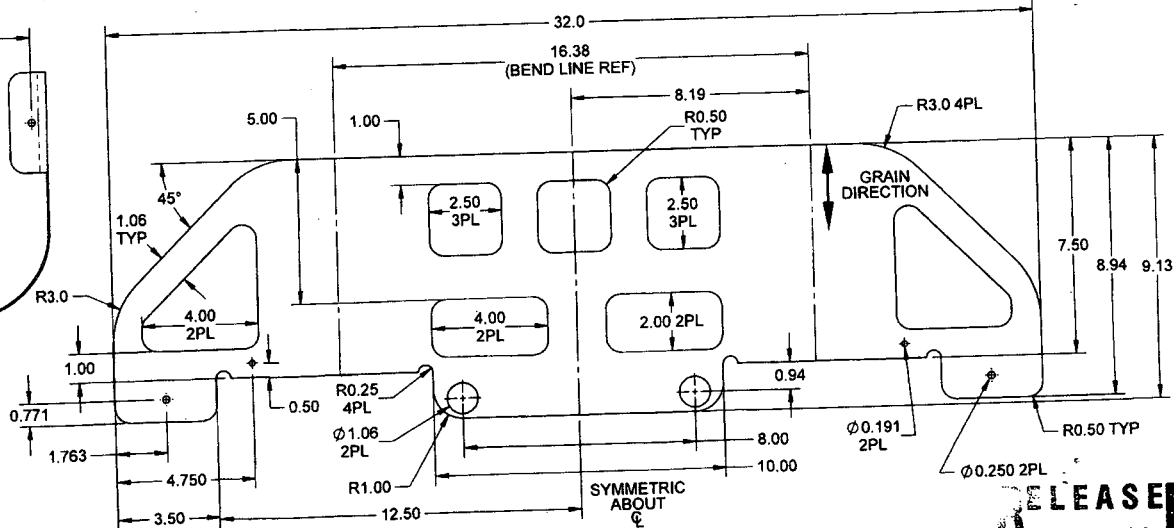
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4812-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.11 lbs

| | | | |
|---------------|-------------|---|--------------|
| A NEW RELEASE | | DB | 13.03.20 |
| REV. | DESCRIPTION | | BY DATE |
| DESIGN | DB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | DB | | |
| CHECKED | A.P. | DRAWING NO. | REV. A |
| MFG. APPR. | 2/ | D4812 | SHEET 1 OF 2 |
| APPROVED | 2/ | TITLE | SCALE |
| DE APPR. | 2/ | PATIENT STOP | NTS |
| DATE | 13.03.20 | <small>COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |



D4812-1 PATIENT STOP
MAKE FROM D4812-1F



D4812-1F FLAT PATTERN

- NOTES:
- 1) MATERIAL: 6061-T6 SHEET, 0.063 THICK PER QQ-A-250/11, AMS-QQ-A-250/11, AMS 4025, AMS 4027 OR ASTM B209
REF: DART SPEC M6061T6S.063
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.04 lbs
 - 8) PROFILE PER DRAWING FILE "D4812-1F-REV A.DXF"

| | | | |
|------------|----------|--|--------|
| DESIGN | DB | DART AEROSPACE LTD | |
| DRAWN | DB | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | AP | DRAWING NO. D4812 | REV. A |
| MFG. APPR. | AP | SHEET 2 OF 2 | |
| APPROVED | AP | TITLE | SCALE |
| DE APPR. | AP | PATIENT STOP | NTS |
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RELEASED
2013-05-16

FIRST ARTICLE INSPECTION CHECKLIST

10.04.15